

Work Order ID 52800 -1

October 14, 2009 10:52:46 AM

Page 1

Item ID: D3969-1
Revision ID: A
Item Name: Gas Spring (Basket Lid)

Accept

Setup Start

Stop

Start Date: 10/14/09 Start Qty: 20.00
Required Date: 10/21/09 Req'd Qty: 20.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: CZ Date: 09/10/13 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3969	A C <u>10.03.29</u>

100 0.00



Purchasing

Purchasing

Memo

Issue P/O: 10572
Order as per Dwg D3969
Possible supplier: LS Technologies
part#: SSA4/6-122-315-310N
Material release note is required

110 0.00



Packaging

Packaging

Memo

Receive & Inspect for Damage & Mat'l Certs



0.00

SPC

(P/E) >

CZ 09/10/14 20

10/14/09 (10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-03-29	Dwg w/o maker	Update chg box to include DSC D3969 Rev.C drawing. Was All ready change at REV.C. 10-03-29				 10-03-29	 10-03-29	

Part No: D3969-1 PAR #: _____ Fault Category: Prod-Eng. Control NCR: Yes No DQA: 7 Date: 10-03-29
 Resolution: re-work Disposition: re-work QA: N/C Closed: _____ Date: _____

NCR: 52800		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/11/14	#100	All struts arrived to Dart with the end fitting loose. R.C not crimped / Design Flaw	<i>[Signature]</i> 09/11/04	- send all struts back re send to Dart to be crimped Q Dart	<i>[Signature]</i> 10/31/18	<i>[Signature]</i> 10/31/18	<i>[Signature]</i> 09/11/04	<i>[Signature]</i> 9/11/14
			<i>[Signature]</i> 10-03-29 pr OSI 042	- up Date Dwg. to show parts to be crimped N/A: Drawing has been previously revised, WO does not have the correct chg attached.	<i>[Signature]</i> 10-03-29	<i>[Signature]</i> 10-03-29 pr OSI 042	<i>[Signature]</i> 10-03-29 pr OSI 042	<i>[Signature]</i> 9/11/14

NOTE: Date & initial all entries

Work Order ID 52800

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Item ID: D3969-1

Accept

Setup Start

Revision ID: A

Stop

Item Name: Gas Spring (Basket Lid)

Start Date: 10/14/09 Start Qty: 20.00

Cust Item ID:

Required Date: 10/21/09 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 272 0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10-3-18 100 SD

10/03/24 CJ
CJ10/31/19

Picklist Print

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Page 1

Work Order ID: 52800

Parent Item: D3969-1

Parent Item Name: Gas Spring (Basket Lid)



Start Date: 10/14/09

Required Date: 10/21/09

Comments:

Start Qty: 20.00

Required Qty: 20.00

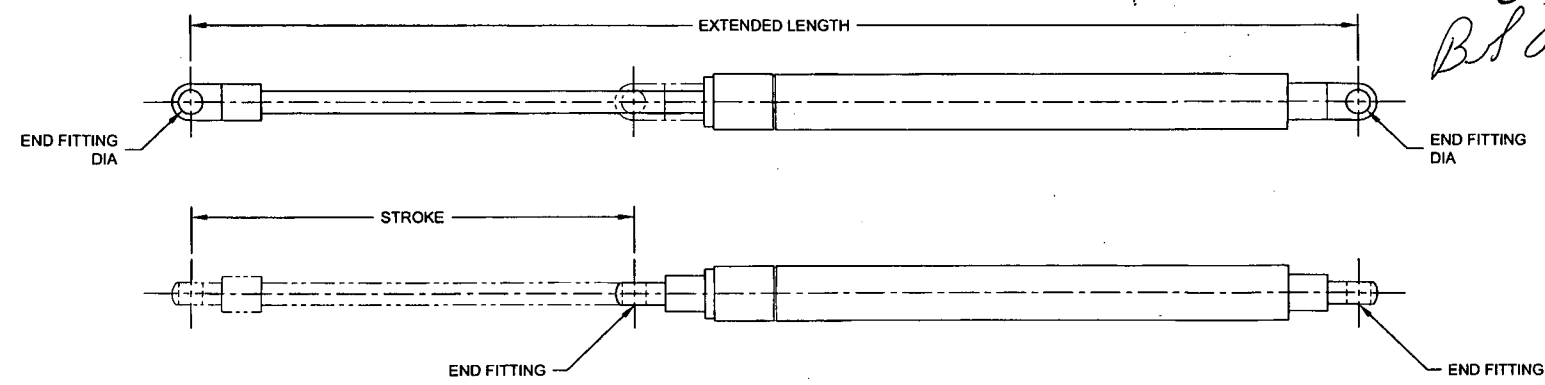
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
SSA4/6-122-315-310N		Purchased	No			110	Each	0.0000	20.0000			
										 <i>Pcy/29</i> <i>10</i>		
Gas Spring												

10/14/09 (10)

SHEET NO. 1
 UNCONT. 11-200
 2 SUBJECT:

WITHDRAWN
 WORK ORDER NO. 52800
 BS 09-10-14

SPECIFICATION CONTROL DRAWING



D3969-X GAS SPRING

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING Ø (in)	MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	310/60.0	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs

RELEASED
 2009 -10- 08

- NOTES:**
- 1) MATERIAL: SEE CHART
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: SEE CHART

A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.	N/A	D3969	SHEET 1 OF 1
APPROVED	MW	TITLE	SCALE
DE APPR.	4	GAS SPRING (BASKET LID)	NTS
DATE	09.07.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

P.O. No.	Date	Packing Slip #
10572	10/28/2009	5462

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Rep	Ship Date	Ship Via
Nolan	10/28/2009	

Qty	Description
10	SSA4/6-122-315-310N Stainless Gas Spring
	Shipped with PO# 10590 on Purolator Tracking # 329146253862
	Total GST
	Business Number: 875007718
	<i>8 u 63 146</i>



303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: lstech@lstechtechnologies.ca www.liftsupporttechnologies.com

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

10 Units: SSA4/6-122-315-310N Stainless Gas Spring

Country of Manufacture: Canada

Date of Manufacture : Oct 2009

This product is ROHS compliant.

8/6/09/13

We certify no mercury was used in the manufacture of this order.

Purchase Order # 10572

Invoice # 5462

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be "Nolan Fehr", written over a horizontal line.

Nolan Fehr
Manager



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10572

Purchase Order Date 10/14/09

PO Print Date 10/14/09

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

FXED
10/14/09

Contact Name
Vendor Phone 306 683 5000
Vendor Fax 306 683 6403
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	SSA4/6-122-315-310N	Gas Spring	10/21/09 Yes	20.00 Each	FedEx Economy <i>New to (10/14/09)</i>	\$65.0000	\$1,300.00

Special Inst: AS PER DWG D3969 REV. A
B52800
LS TECHNOLOGIES P/N: SSA4/6-122-315-310N

PO Total: \$1,300.00

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 10/14/09

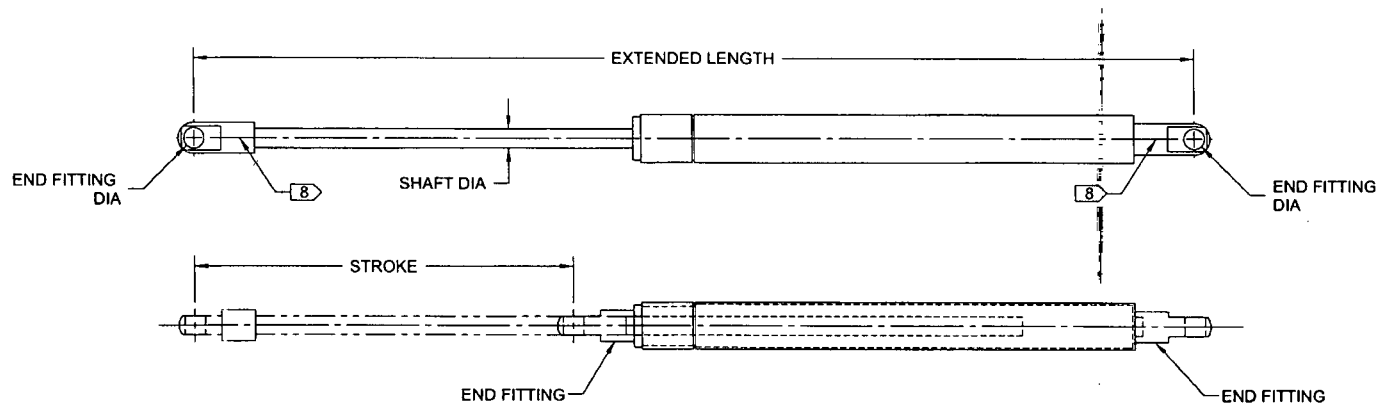
W *CZ*
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

1270 Alverdeen St
Haverksbury. ont.
K1A-1K7

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.	DATE 10/3/10
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO LS Technologies 303-103 Street	
ADRESSE - ADDRESS		Saskatoon SK Canada S7N-1Y9	

[illegible]

SPECIFICATION CONTROL DRAWING



D3969-X SPRING

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	120/4.70	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	120/4.70	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs

RELEASED
2010-03-12

C	REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs).	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO. REV. C	
MFG. APPR.	N/A	D3969 SHEET 1 OF 1	
APPROVED	MD	TITLE SCALE	
DE APPR.	MD	BASKET LID SPRING NTS	
DATE	10.03.04	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

REFERENCE ONLY

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS